

Work Order ID 112588

January-30-14 11:50:44 AM

112588

Page 1

Item ID: D206-651-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206A/B GHW

Start Date: 1/30/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 1-02-03

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-651	B
D2690	B2

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-651-041 CHG001

W/A

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut two cable CBL-1240 per assembly (10.75" each) Remove 2.25" of sleeve from each end of cable CBL-1240-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)3-Install Lanyard D2690-8 (from open end) into pin D2711 a

6x

14/02/05

DAS
36
9-80

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206A/B GHW

Start Date: 1/30/14 Start Qty: 6.00

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Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(6) 14-02-05

DAS

9

9-89

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-651-041

CHG001 Location: PK12 PPP Rev: _____

6x DAS 28 14-02-6 9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14-02-6

14-02-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

January-30-14 11:50:43 AM

Page 1

Work Order ID: 112588
 Parent Item: D206-651-041
 Parent Item Name: 206A/B GHW

Start Date: 1/30/14 Required Date: 1/30/14
 Start Qty: 6.00 Required Qty: 6.00

Comments: IPP Rev: F 02.08.14 Re-format KJ
 IPP Rev: G Removed Purchasing 07-03-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CBL-1240 Cable		Purchased	No				f	96.3084		12		14/02/05	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				96.3084		12			
				123283				96.3084					
CBL-460 Loop Sleeve		Purchased	No				Each	294.0000		24		14/02/05	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				294					
				125499				50		24			
				m127811				289					
D2692 Spring Pin Clip		Manufactured	No				Each	201.0000		6		14/02/05	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST016				201		6			
				74121				13					
				91240				188					
D2711 Lock Pin		Manufactured	No				Each	75.0000		6		14/02/05	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST016				75					
				90501				8					
				91165				50		6			
				93657				17					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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FAULT CATEGORY

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Picklist Print

January-30-14 11:50:43 AM

Page 2

Work Order ID: 112588
Parent Item: D206-651-041
Parent Item Name: 206A/B GHW

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 6.00

Required Qty: 6.00

MS21042L3
Nut

Purchased No

Each 4,943.0000

12

DAS
36
9-89

14/02/05

Location	Loc Qty	Loc Code
ST314	988	
M127304	872	
M127831	116	
ST506	955	
123900	955	
ST509	3000	
M127410	3000	

M126333 (120)

MS27039-1-08
Screw

Purchased No

Each 1,053.0000

12

DAS
36
9-89

14/02/05

Location	Loc Qty	Loc Code
GA	51	
m125654	51	
st507	1002	
m126319	2	
m127255	500	
m127813	500	

12

NAS1149D0363J
Washer

Purchased No

Each 2,922.0000

24

DAS
36
9-89

14/02/05

Location	Loc Qty	Loc Code
GA	78	
124392	78	
ST510a	2844	
m126319	1652	
m127813	1192	

24

DQA: _____ Date: _____



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Transport									
Unapproved									

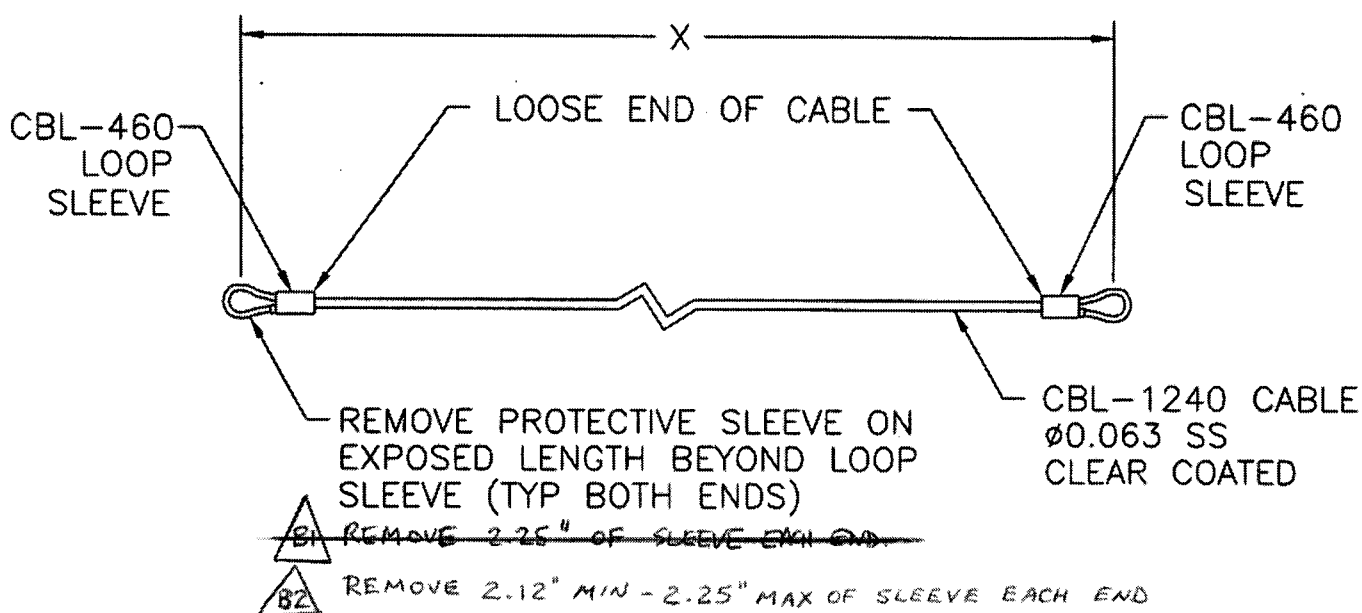
FAULT CATEGORY

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DESIGN <i>MEY</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MEY</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	KE 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.
*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

112588 MS
1102-03

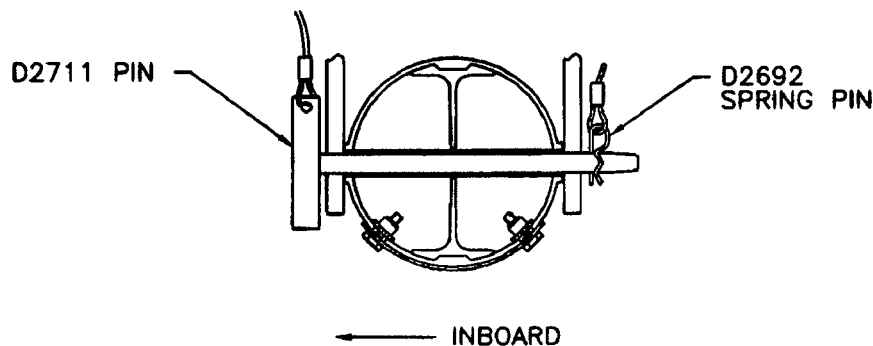
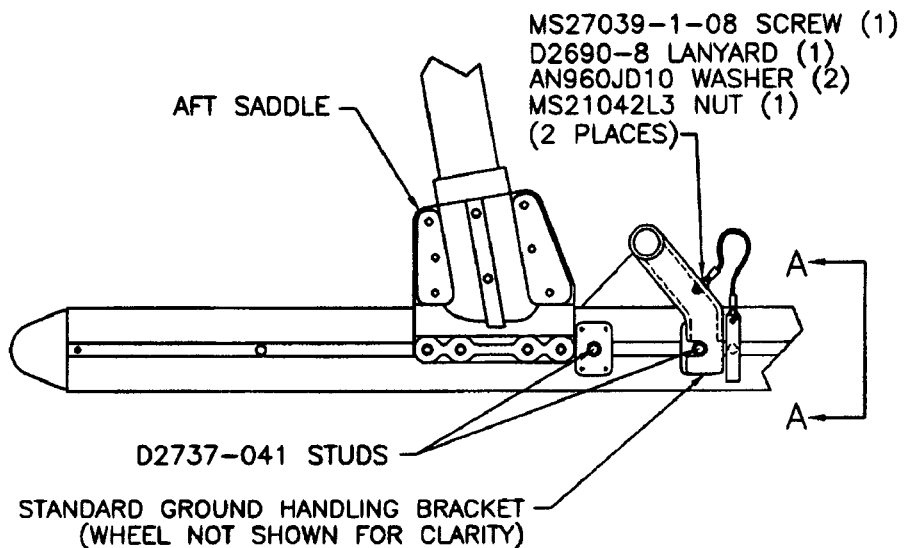
DEO's

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-651	REV. B SHEET 1 OF 1
DATE 98.01.27		TITLE GND. HANDLING WHEEL (GHW) INST.	SCALE NTS
A	97.11.03	NEW ISSUE	
B	98.01.27	D2688 REPLACED BY D2737-041	

TO ADAPT STANDARD BELL GROUND HANDLING WHEELS TO DART 206A/B SKIDTUBES:

1. ATTACH D2711 PIN AND D2692 SPRING PIN TO THE GROUND HANDLING BRACKET BY DRILLING $\phi 0.191$ HOLES IN THE FWD FACE OF THE BRACKET AND USING THE LANDYARDS AND HARDWARE PROVIDED.
2. THE STANDARD BRACKET PICKS UP ON THE STUDS IN FRONT OF THE AFT SADDLE. SLIDE INTO PLACE AND INSTALL THE PIN SUPPLIED TO PREVENT THE UNIT FROM SLIPPING DURING GROUND HANDLING (SEE BELOW).
3. GROUND HANDLE IN THE NORMAL FASHION.
4. REMOVE THE BRACKET FOR FLIGHT. LEAVE THE PINS ATTACHED TO THE BRACKET.



VIEW A-A

112588
MCS
1402-03